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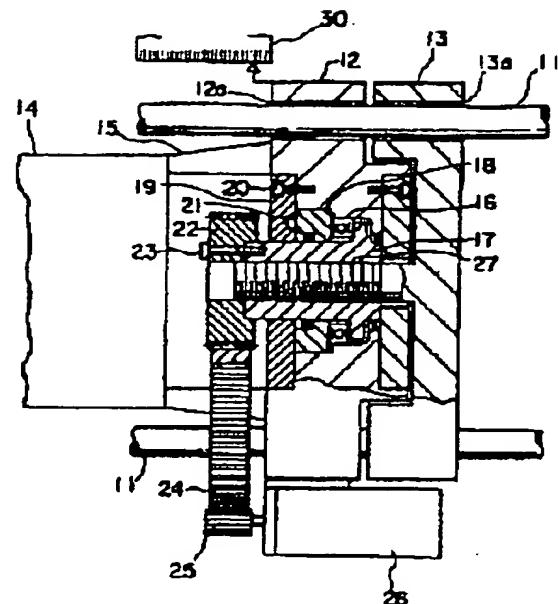
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TITLE : METHOD OF CONTROLLING
INJECTION MOLDER



ABSTRACT : PURPOSE: To make high quality molding possible by a method wherein molds are once completely closed together and, after that, opened by the predetermined amount and, under the condition just mentioned above, injection is performed and finally the molds are compressed again by means of a servo motor.

CONSTITUTION: By driving an AC servo motor 26, the value of pressure detected with a load cell 21 is raised. The AC servo motor 26 is driven so as to raise the pressure up to the predetermined value. The pressure control is performed by feeding-back the output detected with the load cell 21. In succession, the AC servo motor 21 is driven so as to retreat a movable platen by the pre-set mold opening amount with respect to an auxiliary origin so as to open molds. Then, injection is performed under the above-mentioned state. Further, when the predetermined compression starting command is obtained, the AC servo motor 26 is driven again so as to advance the movable platen 13 in order to carry out the compression action of the molds.

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